

Date: Monday, 28/05/2007 9:11:24 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 STEP END PLATE
 Job Number : 32404
 Estimate Number : 11015
 P.O. Number : N/A Part Number : D267334
 This Issue : 28/05/2007 S.O. No. : N/A Drawing Number : D2673 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : B
 Previous Run : 32404 Material : N/A
 Due Date : 04/06/2007 Qty: 112 Um: Each
 Written By : [Signature]
 Checked & Approved By : [Signature]
 Comment : Est. C 02.01.14 Removed deburr and inspect level 5 NG/EC
 Est Rev:D Now 6061-T6 06-06-23 JLM
 Est Rev:C Now on Waterjet 07-05-28 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M6061T6S080 6061-T6 .080 Sheet



Comment: Qty.: 0.1913 sf(s)/Unit Total : 21.8082 = 114 ← Qty
~~19.1310 sf(s)~~

6061-T6 .080 Sheet

(M6061T6S080)

Note: 1 Blank makes 2

Material Batch 4104186

SAP

07/06/01

112

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2673

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

SAP
DM

07/06/01

07/06/11

112
(112)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAP 07/06/01

112

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SAP 07.06.01

112

Date: Monday, 28/05/2007 9:11:24 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 STEP END PLATE

Job Number: 32404

Part Number: D267334

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WHT*

112
112
07-06-14

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.06.15

Job Completion



112
07-06-15

Date: Wednesday, 5/16/2007 1:40:40 PM
User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|--|------------------|------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : 350 STEP END PLATE |
| Job Number | : 32404 | | |
| Estimate Number | : 11015 | | |
| P.O. Number | : | Part Number | : D267334 |
| This Issue | : 5/16/2007 S.O. No. : | Drawing Number | : D2673 REV B |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : / / Type : MACHINED PARTS | Drawing Revision | : B |
| Previous Run | : 25396 | Material | : |
| Written By | : | Due Date | : 6/5/2007 Qty: 100 Um: Each |
| Checked & Approved By | : <u>Jim.05.16</u> | | |
| Comment | : Est. C 02:01.14 Removed deburr and inspect level 5 NG/EC Est Rev:D Now 6061-T6 06-06-23 JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-------------|--------------------|
| 1.0 | M6061T6S080 | 6061-T6 .080 Sheet |
|-----|-------------|--------------------|



Comment: Qty.: 0.1913 sf(s)/Unit Total : 19.1310 sf(s)
6061-T6 .080 Sheet
(M6061T6S080)
Note: 1 Blank makes 2
Material Batch _____

W. H. H. H. H.

| | | |
|-----|-------|-------|
| 2.0 | SHEAR | SHEAR |
|-----|-------|-------|



Comment: SHEAR
Shear blanks: 5.10 X 3.30 +0.000/-0.010 (use off-cuts)

| | | |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1
Machine per H2673

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|-----|--------------|
| 5.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|------|------|----------------------------------|----------------------|---------------------------------|----------------|--|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action | | Section B | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 5/16/2007 1:40:40 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 STEP END PLATE

Job Number: 32404

Part Number: D267334

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

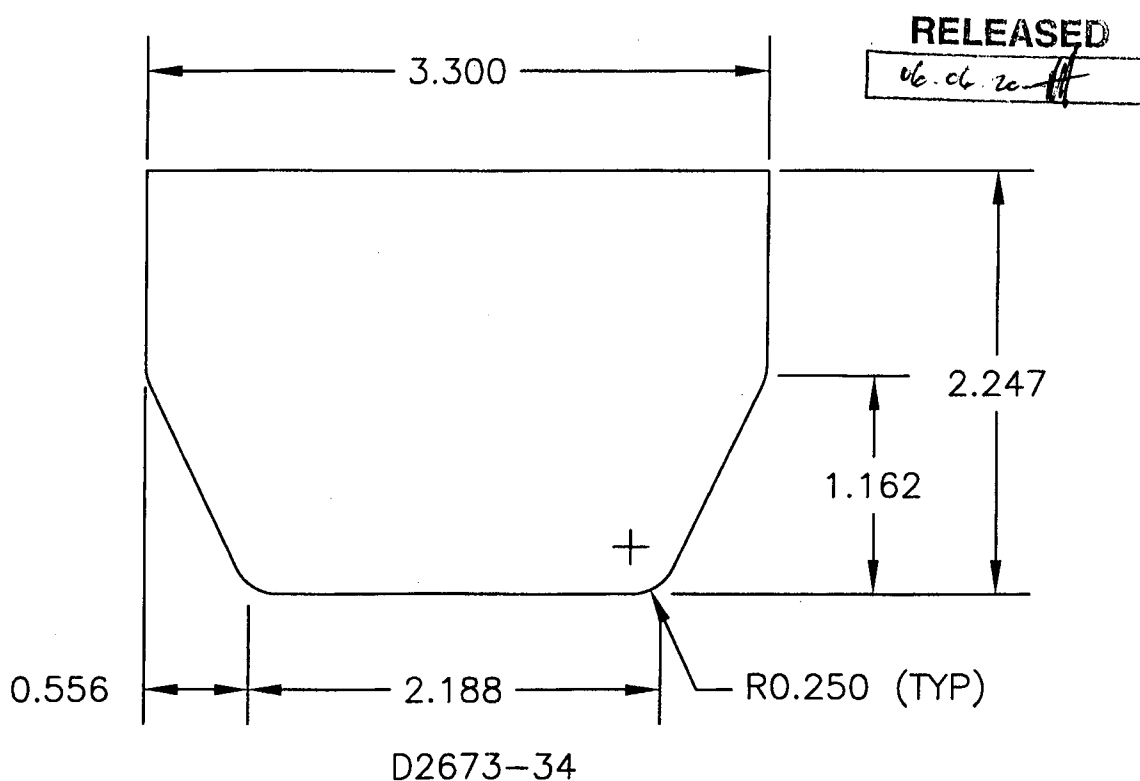
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|------|------|----------------------------------|----------------------|---------------------------------|-----------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action | | Section B | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | | Sign & Date | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |

NOTE: Date & initial all entries

DART

| | | | |
|------------------|--------------------------------|---|------------------------|
| DESIGN BW | DRAWN BY CB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED PH | APPROVED <i>[Signature]</i> | DRAWING NO. D2673 | REV. B SHEET 1 OF 1 |
| DATE 06.05.29 | | TITLE END PLATE | SCALE 1:1 |
| A | 97.05.06 | NEW ISSUE | |
| B | 06.05.29 | ADD 6061-T6 MATERIAL | |

END PLATE FOR D2244 EXTRUSION CUT AT 34°

**NOTES:**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027)
0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016)
0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32404

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